

Date: Friday, 12/15/2006 7:54:43 AM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BUSHING
Job Number : 29907	
Estimate Number : 11148	
P.O. Number : <i>N/A</i>	Part Number : D32093
This Issue : 12/15/2006 S.O. No. : <i>N/A</i>	Drawing Number : D3209 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 12/12/2006 Type : MACHINED PARTS	Drawing Revision : A
Previous Run :	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 12/22/2006
Checked & Approved By :	Qty: <i>38</i> Um: Each
Comment : Est A 04.04.14 New issue KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M303R0500	303 Round Bar 0.500"
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Comment: Qty.: 0.0350 f(s)/Unit Total : 0.6993 f(s) = 1.33

Delrin Round Bar .50" black

Material: AISI 303 SS Ø0.50"

(M303R0.500)

Identify for D3209-3 Batch: *1102447*

MS/2.8 26/12/15 (38)

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

Turn D3209-3 bushing as per Folio FA354 and Dwg D3209

MS/2.8 66/12/15 (38)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS/2.8 06/12/15 (38)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

MS/2.8 06/12/15 (38)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *57416*

[Signature] (38)

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Drawing Name: BUSHING

Job Number: 29907

Part Number: D32093

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(3e)

Comment: FINAL INSPECTION/W/O RELEASE

2006/12/15

Job Completion

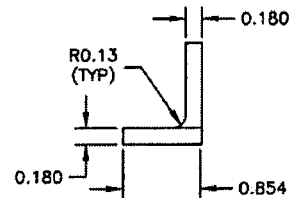
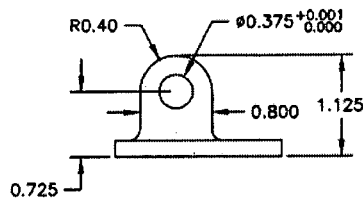
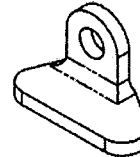
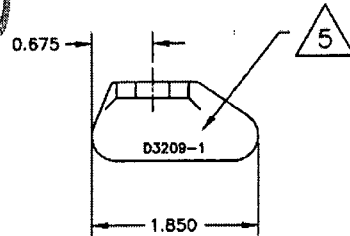
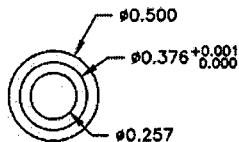
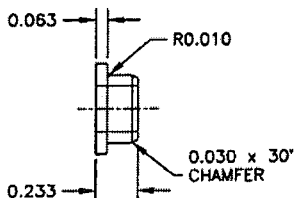


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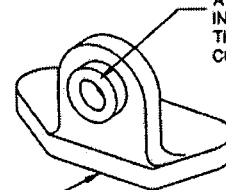
DART

DESIGN FF	DRAWN BY FF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED FF	APPROVED FF	DRAWING NO. D3209	REV. A SHEET 1 OF 1
DATE 04.01.27	TITLE BRACKET		SCALE 1:2
A	04.01.27	NEW ISSUE	

RELEASED
04.04.05

**D3209-1 BRACKET****D3209-3 BUSHING
SCALE 1:2****D3209-041 ASSEMBLY**

D3209-3 BUSHING
PRESS FIT, HEAD
AT THIS FACE
INSTALL AFTER
THE CONVERSION
COAT

**D3209-1 BRACKET; D3209-3 BUSHING**

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
ALUMINUM BAR (M6061T6B)
- 3) MATERIAL: AISI 303 SS (M303R)
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) ENGRAVE DART P/N AS SHOWN
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE INCHES

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NO. 29907

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